Date:

Monday, 11/08/2008 10:20:26 AM

User:•	Linda Lacelle	Process Sheet
Customer Job Number Estimate Num	: CU-DAR001 Dart Helicopters Services : 41084 ber : 13362	Drawing Name : SEAT PAN (AFT FACING LH/RH)
P.O. Number This Issue Prsht Rev. First Issue Previous Run	: 13362 : 11/08/2008	Material :
Written By Checked & Ap	proved By	Due Date : 28/08/2008 Qty: 10 Um: Each
Comment		04 DL verified by:DD
Additional Pro	oduct \	
Job Number:		
Seq. #:	Machine Or Operation:	Description :
1.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
Co	pmment: HAND FINISHING THERMOFORMING	3
	Set up machine program D3774-1 Set up clamping frame as per folio	BB 08/08/14
2.0	MLEXS125F6002904	GE PLASTICS LEXAN SHEET
Co	GE PLASTICS LEXAN SHEET	106.6700 sf(s)
	Batch # M 105330	35-08/09/14
3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
Co	pmment: HAND FINISHING THERMOFORMING	33 CO 08/14 X/O
	1) Cut Blanks	BB 08/08/14 .X(O
4.0	THERMOFORMING	THERMOFORMING MACHINE
Co	Domment: THERMOFORMING MACHINE	1 11111 11111 11111 11111 11111

Thermoform as per Dwg. D3774-1and Folio

PB 08/08/15/X10

## Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
	-	*									
		. <u> </u>									
,											
	<i>3</i> 7										

Part No:	1	PAR #:		Fault Category:	NCR: Yes No DQA:	Date:
•	-	4	, 7		<del></del>	
	-				QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B	Verification	Annanal	A					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector				
			,									
		·										
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			7					, ,				
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NOTE: Date & initial all entries

Date: Monday, 11/08/2008 10:20:26 AM User: Linda Lacelle **Process Sheet** Drawing Name: SEAT PAN (AFT FACING LH/RH) Customer: CU-DAR001 Dart Helicopters Services Job Number: 41084 Part Number: D37741 Job Number: Seq. #: Description: Machine Or Operation: INSPECT PARTS AS THEY COME OFF MACHINE 5.0 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 6.0 HAND FINISH TH HAND FINISHING THERMOFORMING Comment: HAND FINISHING THERMOFORMING KIO 1) Trim to Finished Dimensions INSPECT PARTS AS THEY COME OFF MACHI 7.0 Comment: INSPECT TRIMMED PARTS 10 DL 08.08.27 1) Check dimensions to ensure conformity to drawing tolerances. INSPECT WORK TO CURRENT STEP 8.0 QC5 Comment: INSPECT WORK TO CURRENT STEP PACKAGING 1 PACKAGING RESOURCE #1 9.0 Comment: PACKAGING RESOURCE #1 10.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE Job Completion 

Dart Ae	rospace	Ltd							
W/O:			WC	ORK ORDER CHANGES					
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	ICR: Yes	No <b>DQ</b>	A:	Date:	
		1			QA: N	C Close	d:	Date: _	
NCR:			WORK ORD	ER NON-CONFORMAN	CE (NCR	)			
DATE	STEP	Description of NC		0: 0	Verification		Approval	Approval	
	OIL!	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	ion C	Chief Eng	QC Inspector
							,		

NOTE: Date & initial all entries

						# /
DART AEROSE	PACE LTD			Wo	ork Order:	41084
Description: S <sub>E</sub>	AT PAN (A)	T FACIN	(6)	Pa	art Number:	D37741
Inspection Dwg: f						Page 1 of 1
		TIOL E INO	DEOTION		LICT	
	<u></u>	RTICLE INSI				
	X	First Article		Prototy	pe	
	TH	ERMOFORI	WING SE	CTION		
Description			Accept	Reject	Method of Inspection	LOMMONTS
Inside Radii less th	ian		<b>F</b>		ļ	
Shape Definition			N. C.	-	V.S	
Texture Retention	one such as humns of	racke voide	1 h		Vis	
scratching	Material imperfections such as bumps, cracks, voids, scratching				Vis	
			<del> </del>		<del>                                     </del>	
		*	_			
Measured by:	Dl.		]		Date	: 68 08 H
		TRIMMING	SECTIO	) N		
Drawing	T	Actual	1		Mathad of	
Dimension	Tolerance	Dimension	Accept	Reject	Method of Inspection	Lommanis
4.3"	+/- 0,1004	1,325"				
33,911	+/- 0.1001	33,875"				
17.4"	1/- 0.10011	17.5"				
<u>6.085"</u>	MIN	0.0941	-			
0.(004	MIN	0.140"	-			
0,100"	MIN	0.143"	1			
0, 00"	MIN	0.174"				
0,100"	MIN	0.153"	<u> </u>			
	<del> </del>				<del> </del>	<u> </u>
					<u> </u>	
	<u> </u>	L	l		<u> </u>	
Measured	by: A-		]		Date	: 08.08.26
Audited	by:		]		Date	: 06.0626
Prototype Approv				Date	:	
Rev Date			Revise	ed by Approye		
	Change New Issue				KJ/DL	1/

							PD.
DART AEROSP	ACE LTD			Wo	rk Order:	41	084
Description: SE	AT PAN (A)	T FACIN	c)	Pa	rt Number:	DB	7741
Inspection Dwg: \$	)3774 Rev: /ˈ₹					P	age 1 of 1
		RTICLE INSF	PECTION	CHECK	LIST		
	[ <del></del> ]	First Article		Prototy			
	لــــا	ERMOFORM	ـــــ IING SE	-			
<u> </u>			<u> </u>	T	T ==		
Description			Accept	Reject	Method of Inspection		Comments
Inside Radii less th	an"						
Shape Definition			Nh		Us		
Texture Retention		L'h		Vis			
Material imperfection scratching	Material imperfections such as bumps, cracks, voids, scratching				V15		
		· · · · · · · · · · · · · · · · · · ·				-	
Measured by:			Date	: 88	.88.7/		
	•	TRIMMING	SECTIO	ON			<i>C</i>
Drawing		Actual			Method of		
Dimension	Tolerance	Dimension	Accept	Reject	Inspection		Comments
43"	+/- 0,100"	1.36"			Vern		
33,911	+/- 0.1001	33 875"			TAPL		
17.4"	1/- 0.100"	17.5"	V		TARC		
<b>6</b> ,085"	MIN	0.097"	V		Cal		
0.(00"	MIN	6.158"	<u> </u>		Col		
0,100"	MIN	<i>€./37"</i>	<u></u>		Cul		
0.10011	Min	0.161"			Cal .		
0.1004	MIN	0.156			Cel.	-	
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						1	
Measured	by: When	1,		<del></del>	Date	: 08	08.36.
Audited	"/)		, 		Date		
Prototype Approv					Date		c8·26
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DART AEROSPA	ACE LTD			Wo	rk Order:	41084
Description: S <sub>€</sub>	AT PAN (AE	T FACING	(c)	Pa	rt Number:	D37741
Inspection Dwg: (5)	3774 Rev: 12					Page 1 of 1
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	<del></del>	TICLE INSP				
	X F	irst Article		Prototyp	е	
	ТНІ	ERMOFORM	IING SE	CTION		
Description			Accept	Reject	Method of Inspection	
Inside Radii less tha	an					
Shape Definition			i de		Us	
Texture Retention			iSil		215	
	Material imperfections such as bumps, cracks, voids,				Vis	
scratching	WILL		\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \			
				L		
Measured by:	- Ph.				Date	: 28.08.26
	·	TRIMMING	SECTIO	N		
Drawing		Actual			Method of	Comments
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	
1,3"	+/- 0,100"	1.33"	1/		Very	
33.411	+/- 8.100"	33.875"			Tall	
17.4"	1/- 0.100"	17511	/		Tase	
6,085"	MIN	0.088"	1/		C.D	
0.(004	MIN	1.421	~		CI	
0,100"	MIN	1.15"			Call	
0.10011	MIN	1.11 1			Cal	
0.100"	MIN	1.30"			Cal	
	·					
Measured b	py: 69/4				Date	: 68.08.26
Audited b	DY: 0806	28			Date	: 8/8/28
Prototype Approv	v				Date	:
Rev Date C	hange				Revis	ed by Approved
	lew Issue				KJ/DL	

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	•						44
DART AEROSI	PACE LTD			Wo	rk Order:	410	184
Description: S	EAT PAN (A)	T FACIN	<u>a)</u>	Pa	rt Number:	D32	7741
						Pa	ge 1 of 1
Inspection Dwg:						Га	gerorr
	FIRST AR	TICLE INSP	ECTION	CHECK	LIST		
	X	First Article		Prototy	oe		:
	TH	ERMOFORN	ING SE	CTION			
Description			Accept	Reject	Method of Inspection		omments
Inside Radii less ti	nan						
Shape Definition	19/4	rte	125				
Texture Retention	19/		Jus-	<u> </u>			
Material imperfect scratching	261		Vis	_			
	-						
Measured by:	191				Date	: 08	20826
•		TRIMMING	SECTIO	) NI			
Dunassina		Actual	J JLO 11C			.	
Drawing Dimension	Tolerance	Dimension	Accept	Reject	Method of Inspection		omments
1.3"	+/- 0,1004	12744			Vein.		
33,911	+/- 0.100"	73.875"	/		Tupe		
17.4"	1/- 0.10011	17.50	1/		Tape	.	
6,085" 0,00"	MIN	0,097"			(0)		
0.(00"	MIN	0.155			Cal	_	
0,100"	MIN	0.134"			Cal		
0,10011	MIN	0.130"			Cal		
0.100"	MIN	0.134"			Col.		
Measured	by: Wh				Date	: 08	08.H
Audited	by:				Date	: 8/	8/28
Prototype Appro	val:				Date	):	
Rev Date	Change				Revis	ed bv	Approved
A Date	New Issue	· · · · · · · · · · · · · · · · · · ·			KJ/DL		

DART AEROSPA	ACE LTD			Wo	rk Order:	41084
Description: 5	AT Pans (A)	T FACIN	<u>(,)</u>	Pa	rt Number:	D3774/
						Domo 4 of 4
Inspection Dwg: 5)	3774 Rev: B					Page 1 of 1
	FIRST AR	TICLE INSP	PECTION	CHECK	LIST	
•	X	First Article		Prototyp	e	
	TH	ERMOFORM	ING SE	CTION		,
Description		· · · · · · · · · · · · · · · · · · ·	Accept	Reject	Method of Inspection	Comments
Inside Radii less tha	"					
Shape Definition			24		V15_	
Texture Retention			19		29.5	
Material imperfection	ns such as bumps, c	racks, voids,	Nh,		Vis	
scratching			Na,		V13	
	·					
	747					
Moscured by	0.1				Date	
Measured by:	Jh, -				Date	08.08.76
		TRIMMING	SECTIO	N		
Drawing	<u> </u>	Actual			Method of	
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
	<u> </u>					
1.3"	+- 0.1004	1,317"	1		Ver.	
33.911	+/- 0.100"	<u> 33,875</u>	1/		Jupl	
17.4"	1/- 0.10011	17.5"			Johl	
6,085"	MIN	0.091"			Col_	
0.(00"	Min	01154			col	
0,(00"	MIN	0.114"	V	_	Calla	
0:100"	MIN	0.1144			Cal	
0.100"	MIN	1 122"	/		Cal	
	, , , , , , , , , , , , , , , , , , ,	0,100	<b>*</b>		-	
		<u> </u>	L	1		
Measured b	y: \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \				Date	: 08 08 %
Audited b	y: &				Date	: 04/06/18
Prototype Approva					Date	
	hange				D	d hy Anneous
	<u> </u>		Revise KJ/DL	ed by Approve		
A N	ew Issue					



Revised by KJ/DL Approved

•						# Z
DART AEROSPA	ACELTD		<u> </u>	Wo	rk Order:	41084
DAKT AEROSPI	ACE LID		<del></del>	****	ik Oldel.	11001
Description: S	AT PAN (AG	T FACIN	٤)	Pa	rt Number:	D37741
Inspection Dwg: 🔊	3774 Rev: 13					Page 1 of 1
	FIRST AR	TICLE INSP	ECTION	CHECK	LIST	
	XF	irst Article		Prototyp	e	
	TH	ERMOFORM	IING SE	CTION		
Description			Accept	Reject	Method of Inspection	Comments
Inside Radii less tha	" "					
Shape Definition			19/1		Vrs.	
Texture Retention			29/		125	<u> </u>
	ns such as bumps, c	racks, voids,	1.97		Vis	
scratching			vu,		US	
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				L		
Measured by:	- DT.				Date:	08.08.76.
		TRIMMING	SECTIO	N		
Drawing		Actual	_		Method of	
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
1,3"	+/- 0.100"	1,307	V,		Vern	
33.911	+/- 0.100"	33875"			Topi	
17.4"	1/- 0.10011	17,54			Japa	
6,085"	MIN	0.0949	1		20	
0.(00"	MIN	0,143"	<u> </u>		Call	
0,100"	MIN	D,117"			Coh	
0:10011	MIN	0.118			Col	
0.100"	MIN	0,140"	1	<u> </u>	Cel.	熱
		-		<b></b>		
Measured b	\\.\.\.\.\.\.\.\.\.\.\.\.\.\.\.\.\		 	l	Date:	00 (0 1/
			<b>i</b>			100.00
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Prototype Approva					Date:	

Change New Issue

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Date

DART AEROSPA	ACE LTD			Wo	rk Order:	4	1084
Description: S≝	AT PAN (AG	T FACIN	(c)	Pa	rt Number:	D3	7741
						D.	ige 1 of 1
Inspection Dwg: 5)	3774 Rev: 13					F	ige i oi i
	FIRST AR	TICLE INSP	ECTION	CHECK	LIST		
	X F	irst Article	<u>.                                    </u>	Prototy	ре		
	TH	ERMOFORN	ING SE	CTION			
Description			Accept	Reject	Method of Inspection		omments
Inside Radii less tha	in "						
Shape Definition			- 19 <del>7</del> -		UIS		
Texture Retention	ns such as bumps, c	racks voids	Ph		Uis	<u></u>	
scratching	racks, voids,	Ph		013			
				1	D-4		
Measured by:	19/.				Date	e:   💍 🙈	08.26
		TRIMMING	SECTIO	N			
Drawing		Actual		D.:	Method o	f	comments
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	ו ר	oninents
1,3"	+/- 0.100"	1.308"	سمه		Very		
33,911	+/- 0.100"	33.875"	رارا		Japa		
17.4"	4-0.100"	17.5"			Japa		
6,085"	MIN	0.092"	<u></u>		Cal		
0.(00"	MIN	0.160"	N		Cali		
0,100"	MIN	0.145"	-/-		Call		
0.10011	MIN	$\Delta M = L \Delta M = 1$	N		Cala		
0.100"	MIN	0./33"			Cal		
				<u> </u>			
						<del></del>	
				l			
Measured b	y: Joly				Date	e: 06	98 H
Audited b	y: &				Date	e: <i>E/4</i>	0/28
Prototype Approva	al:				Date	e:	
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	hange				KJ/DL		7.65.000

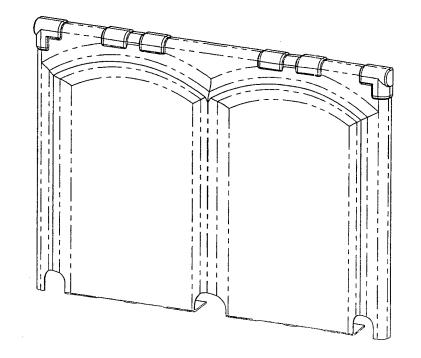
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DART AEROSPACE LTD				Work Order:		411	284
Description: SEAT PAN (AFT FACING				Pa	rt Number:	D37	7741
Inspection Dwg: 5)3774 Rev: /R						Pa	ge 1 of 1
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	FIRST AR	TICLE INSP	ECTION	CHECK	LIST		
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	TH	ERMOFORN	ING SE	CTION			
Description			Accept	Reject	Method of Inspection		omments
Inside Radii less tha	nn "						
Shape Definition			19%		19.5		
Texture Retention			196		115		
	ns such as bumps, c	racks, voids,	191		1		
scratching			<i>1</i> −1ù		VIS		
						·	
Measured by:	Dhe				Date	e: ුද	₹08.26
		TRIMMING	SECTIO	N			
Drawing	Talazanaa	Actual	Accent	Reject	Method o		omments
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	י וי	Ollinients
1.3"	+/- 0,100"	12984	بر.		Vern		
33:911	+/- 0.100"	28875"	1/		Take		
17.4"	4-0.10011	17.51			Tapo		
6,085"	MIN	(0,488°			Call		
0.(00"	MIN	0.131"	_1_		Cal		
0,100"	MIN	0.1174	V		Cal		
0:10011	MIN	0.1174			Call		
0.1004	MIN	0,1304			Cal		
						·	
				- <del>-</del> -			
	L						
Measured by:					Date	e: 0 <b>%</b>	08.26
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DART AEROSPACE LTD				Work Order:		41084	
Description: S と	AT PON (HE	T FACING	<u>(</u> )	Pa	rt Number:	D3774/	
Inspection Dwg: 5)				<del></del> .		Page 1 of 1	
inspection bwg. v)						1 age 1 01 1	
	FIRST AR	TICLE INSP	ECTION	CHECK	LIST		
	X F	irst Article	<u>.                                    </u>	Prototy	oe		
THERMOFORMING SECTION							
Description			Accept	Reject	Method of Inspection		
Inside Radii less tha	n		400		-		
Shape Definition			197		1/19		
Texture Retention  Material imperfection	ne euch ae humne a	racke voide	- Mi		100		
scratching	is such as bumps, c	racks, volus,	21/4		Urs		
Measured by:	Oh				Date	: 08.08.H <sub>e</sub>	
		TRIMMING	SECTIO	N			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	I.Ommenis :	
1,3"	+/- 0,1004	1244					
33.511	+/- 0.100"	38,875					
17.4"	4-0.10011	14.5"	/				
6.085"	MIN	0.092"					
0.(00"	Min	0.1304					
0,100"	MIN	0.175	V_				
0.10011	MIN	0.133"	V				
0.1004	MIN	0.196"	<u> </u>				
			-				
Measured by: 194-					Date	: 08.08.74	
Audited by:					Date	: 8/8/28	
Prototype Approva			Date				
	hange ew Issue				Revis KJ/DL		

DART AEROSPACE LTD				Work Order: \$1887		
Description: SEAT PAN (AFT FACING)				Part Number:		D3774/
						Da 4 - 5 4
Inspection Dwg: \$3774 Rev: [3						Page 1 of 1
	FIRST AR	TICLE INSP	ECTION	CHECK	LIST	
	X F	irst Article		Prototyp	e e	
	L			•		
	I H	ERMOFORM	IING SE	CHON	ı	
Description			Accept	Reject	Method of Inspection	I COMMENTS A
Inside Radii less tha	an					
Shape Definition			06	44	Vis	
Texture Retention			151		Uis	
	ons such as bumps, c	racks, voids,	M.		Vis	
scratching			NUI		013	
	.01		<u> </u>	L	5-1	1 00 0000
Measured by:	pu				Date	: 08.08.76
		TRIMMING	SECTIO	N		
Drawing		Actual			Method of	C
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	
1,3"	+/- 0.100"	1305CL			Dem	
33.911	+/- 0.100"	23.875°C			Japa	
17.4"	1/- 0.100"	17.50	~		June	
6.085"	MIN	0.0974			Call	
0.100"	MIN	0/15"			Cak	
0,10011	MIN	0.117"	/		Col	
0,10011	MIN	0,118"			<u>Col</u>	
0.100"	MIN	0,125"			Cal	
Measured by:					Date	: 0808.26
Audited by:					Date	1 1/2/20
Prototype Approv	val:				Date	·:
Rev Date C	Change				Revis	ed by Approved
	Jaw Issue				KJ/DL	

D3774-1 SEAT BOTTOM



D3774-3 SEAT BACK

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41084

В	UPDATE 3); UPDA HOLES REASO	E CUTOUT DIME ATE MINIMUM T ON D3?74-3 (ZN N: MANUFACTU	PH	08.07.25		
Α	NEW ISSUE				08.06.23	
REV.	DESCRIPTION			BY	DATE	
DESIGN	1	HS	DART AEROSPACE LTD			
DRAWN	1	PH				
CHECK	ED		DRAWING NO.		REV. B	
MFG. A	PPR.	SHO	D3774		SHEET 1 OF 3	
APPRO	VED	NA	TITLE		SCALE	
DE APP	R.	-#	SEAT		NTS	
DATE 08.07.25			COPYRIGHT @ 2008 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

